Wednesday, 3/12/2008 2:01:59 PM

Kim Johnston

**Process Sheet** 

: CU-DAR001 Dart Helicopters Services

Job Number : 37902 : 10532 Estimate Number

P.O. Number

: 3/12/2008

: NC

: 11

: 37901

: SMALL /MED FAB Type

**Drawing Name** 

Part Number **Drawing Number** 

· K10003

: K10003

: SADDLE KIT

Project Number **Drawing Revision** 

: N/A : C

Material

: 4/4/2008 Due Date

Qty:

4 Um:

Each

Checked & Approved By

: Est: 03.01.16

Reformat: Incorporated D205-641-011

Per K10003 Rev C

KJ/RF

Est: 06-07-25

S.O. No. :

06.11.17

As per DSI 9344

JLM Est:

ΚJ

Est Rev: L 07.01.12 Document Record for copying bluefile rmv

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

DC



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003

**CHG 005** 

DOCUMENT CONTROL

2.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0

D2570

Bushing





Comment: Qty.:

24.0000 Each(s)/Unit Total:

96.0000 Each(s)



Bushing

Pick: Qty

Part Number D2570

Description Bushing

24 D2571



4.0

Saddle, Fwd, Out



Comment: Qty.:

1.0000 Each(s)/Unit

Total:

4.0000 Each(s)

Saddle, Fwd, Out

Pick: Qty

1

Part Number

D2571

Description

Saddle

Batch

Page 1

Dart Ae	rospace	Ltd	WORK ORDER CHANGES  PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr   Approval QC Inspector    PAR #: Fault Category: NCR: Yes No DQA: Date: QA: N/C Closed: Date:    WORK ORDER NON-CONFORMANCE (NCR)  Prod Mgr   Approval    Corrective Action   Section B   Size 9   Verification   Approval    Approval   Approval    Approval   Approval   Approval    Approval   Approval    Prod Mgr   Pro								
W/O:		WORK ORDER CHANGES									
DATE	STEP	PRO	PROCEDURE CHANGE		Date	Qty	Chief Eng /	Approval QC Inspector			
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Part No	•	PAR #:	Fault Category:	NCR: Yes	s No DQ	A:	Date: _	·····			
				QA:	N/C Close	d:	_ Date: _				
NCR:		V	WORK ORDER NON-CONF	ORMANCE (NO	R)						
DATE	STEP	Description of NC			Verifi	cation	Approval	Approval			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector			
<u></u>											
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Wednesday, 3/12/2008 2:01:59 PM Date: Kim Johnston Use#: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 37902 Job Number: Description: Seq. #: Machine Or Operation: 5.0 D2572 Saddle, Fwd, In Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Saddle, Fwd, In Pick: Description Qty Part Number Batch D2572 Saddle 1 D2573 Saddle, Aft, Out 6.0 Batch ~ comp. 4.0000 Each(s) Comment: Qty.: 1.0000 Each(s)/Unit Total: Saddle, Aft, Out Pick: Batch Description Qty Part Number D2573 Saddle 1 D2574 Saddle, Aft, In Comment: Qty.: , 1.0000 Each(s)/Unit 4.0000 Each(s) Total: Saddle, Aft, In Pick: Qty Part Number Description Batch D2574 Saddle 1 D27361 8.0 Lug Assembly Comment: Qty.: 4.0000 Each(s) 1.0000 Each(s)/Unit Total: Lug Assembly Pick: Qty Part Number Description D2736-1 Bracket 1 D27363 Lug Assembly Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Lug Assembly Pick: Batch Qty Part Number Description 37928x1 37154 x3 D2736-3 **Bracket** 1

Dart Ae	rospace Lt	ď						
W/O:			WORK ORDER	CHANGES	, · · · · · · · · · · · · · · · · · · ·		1	
DATE	STEP	PRO	CEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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						-		
	1					<u> </u>		<u> </u>
Part No	•	PAR #:	Fault Category:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
				QA:	N/C Close	d:	_ Date: _	·
NCR:		V	VORK ORDER NON-CON	FORMANCE (NO	R)			

NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
		Description of NC		Corrective Action Section B			AI					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector				
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Date: Wednesday, 3/12/2008 2:01:59 PM Kim Johnston User: **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: SADDLE KIT Job Number: 37902 Part Number: K10003 Job Number: Seq. #: Machine Or Operation: Description: 10.0 D2747 Set Screw Comment: Qty.: Total: 16.0000 Each(s) 4.0000 Each(s)/Unit Set Screw Pick: Description Batch Qty Part Number 4 D2747 Socket Head Set Screw 11.0 D2876 Saddle Spacer Comment: Qty.: 8.0000 Each(s) 2.0000 Each(s)/Unit Total: Saddle Spacer Pick: Description Qtv Part Number 2 D2876 Spacer 12.0 D2877 Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Saddle Spacer Pick: Qty Part Number Description 2 D2877 Spacer D2968041 13.0 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Tow Ring Pick: Description Qty Part Number D2968-041 Tow Ring 1 D35331 14.0 Set Screw Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Set Screw **38**28093 Batch: AN46A 15.0 Bolt Comment: Qty.: 16.0000 Each(s)/Unit Total: 64.0000 Each(s) Bolt M106662 Pick: Page 3

# **Dart Aerospace Ltd**

ospace	Ltu											
		WORK ORDER CHANGES										
STEP	Р	ROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
		·										
	71-1 <sub>2</sub> -44											
:	PAR #:	Fault Category:	NCR: Ye	s No DQ	<b>A</b> :	Date: _						
			QA	: N/C Close	d:	_ Date: _						
		WORK ORDER NON-CON	IFORMANCE (NO	CR)								
	STEP		STEP PROCEDURE CHANGE  :PAR #: Fault Category:	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By  E PAR #: Fault Category: NCR: Ye	WORK ORDER CHANGES  STEP PROCEDURE CHANGE By Date  By Date  PAR #: Fault Category: NCR: Yes No DQ	WORK ORDER CHANGES           STEP         PROCEDURE CHANGE         By         Date         Qty            PAR #: Fault Category: NCR: Yes No DQA:         QA: N/C Closed:	WORK ORDER CHANGES           STEP         PROCEDURE CHANGE         By         Date         Qty         Approval Chief Eng / Prod Mgr					

	WORK ORDER NON-CONFORMANCE (NCR)									
STEP	Description of NC		Corrective Action Section B			Annessal	Ammercal			
	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector			
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	The state of the s									
	STEP	STEP Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP Description of NC Corrective Action Section B Verification Section A Action Description Sign & Section C	STEP Description of NC Corrective Action Section B Verification Approval Section A Section C Chief Eng			

Wednesday, 3/12/2008 2:02:00 PM Date: Kim Johnston User: **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 37902 Job Number: Seq. #: Description: **Machine Or Operation:** Part Number Description Batch Qty 16 AN4-6A Bolt AN446A Bolt 16.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s) Bolt Pick: Description Qty Part Number MIO tous 08/04/28/K AN4-46A Bolt 4 Bolt AN451A Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s) Bolt Pick: Description Batch Part Number Qty M04662 AN4-51A Bolt 8 18.0 AN612A Bolt Comment: Qty.: 32.0000 Each(s) 8.0000 Each(s)/Unit Total: Bolt Pick: Qty Part Number Description Batch M 10651 8 AN6-12A Bolt 19.0 AN960JD416 Washer Comment: Qty.: 32.0000 Each(s)/Unit Total: 128.0000 Each(s) Washer Pick: Qty Part Number Description Batch 32 AN960JD416 Washer Washer AN960JD616 20.0 Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s) Washer Pick: Description Qty Part Number Batch 8 AN960JD616 Washer

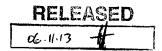
Dart Ae	rospace	Ltd								
N/O:			V	ORK ORDER CHAN	IGES					-
DATE	STEP	PRO	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Ca	tegory:	NC	R: Yes	No <b>DQ</b>	<b>A</b> :	_ Date: _	
						QA: N	/C Closed	d:	_ Date: _	
NCR:			WORK OR	DER NON-CONFORT	MANCE	(NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action S Action Description Chief Eng	ection B	Sign &	Verific Section		Approval Chief Eng	Approval QC Inspector
			Olioi Elig	Office Elig		Date				
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Wednesday, 3/12/2008 2:02:00 PM Date: User: Kim Johnston **Process Sheet** Drawing Name: SADDLE KIT Customer: CU-DAR001 Dart Helicopters Services Part Number: K10003 Job Number: 37902 Job Number: Description: Seq. #: Machine Or Operation: Washer 21.0 AN9704 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Washer Pick: Description Batch Qty Part Number M107242 Washer AN970-4 1. MS21042L4 Nut Comment: Qty.: Total: 116.0000 Each(s) 29.0000 Each(s)/Unit Nut Pick: Description Batch Qty Part Number MS21042L4 Nut (or MS21042-4) 29 INSPECT 100% KITS FOR COMPLETENESS QC4 23.0 Comment: INSPECT KITS 100% FOR COMPLETENESS 24.0 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 25.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Ae	rospace l	Ltd											
N/O:			WORK ORDER CHANGES										
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	Fault Cate	egory: NC	R: Yes	No DQA	\:	_ Date: _					
					QA: N	/C Closed	l:	_ Date:					
NCR:			WORK ORD	DER NON-CONFORMANC	E (NCR	()			* ***				
		Description of NC	Corrective Action Section B			Verific		Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector				
								-					



	DESIGN DRAWN BY  CHECKED APPROVED,		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
			APPROVED,	DRAWING NO.	REV. C				
	f	H		K10003	SHEET 1 OF 1				
	DATE		<u> </u>	TITLE	SCALE				
	06.1	1.07		SADDLE KIT	NTS				
	Α		00.06.01	NEW ISSUE					
	В		00.11.22	ADD D2707-041 OPTION					
	C		06.11.07	ADD D3533-1					



THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION	
BELL 205/210/212/412	D205-634-011	
	D205-634-015	
BELL 204	D204-635-011	

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011	
D205-641-011	1	1	1	
D2570	16	16	16	
D2571	1	1	1	
D2572	1	1	11	
D2573	1	1	1	
D2574	1	- 1	1	
D2747	4	4	4	
D2876	2	2	2	
D2877	2	2	2	
D2707-041 (or D2968-041)	1	1	1	
D3533-1	2	2	2	
AN4-51A	8	8	8	
AN4-6A	16	16	16 SHOP (3)	DV
AN6-12A	8	8	8 Short	TO
AN960JD416	32	32	32 - SINT 3	RING
AN960JD616	8	8	8 GONTROIL	ED CO5
*AN960JD1016	11	1	GLDTICT TO A	END/EX
AN970-4	1	1	1 WITHOU	ZOLL E
MS21042-4 (OR L4)	25	25		10 Ld
* RE(	QUIRED WITH D2	707-041 ONLY	NO.3-1-	702

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